User:

Friday, 17/10/2008 12:43:59 PM

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Type

: 42724

Job Number **Estimate Number** : 13475

P.O. Number This Issue

: 17/10/2008 S.O. No. :

Prsht Rev. : NC First Issue

: //

: 40969

Part Number

Drawing Number

Drawing Name

: D3763045 : D3763 REVB

: N/A

: END FITTING ASS'Y

Project Number

: B **Drawing Revision**

Material

Due Date : 10/11/2008

Qty:

4 Um:

Each

Written By

Checked & Approved By

Comment

Previous Run

new issue DD verified by:ec Est Rev:B 08-08-11 add chemical coat and qc3 DD verified

: SMALL /MED FAB

by:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

2.0



End Fitting



Comment: Qty.:

1.0000 Each(s)/Unit Total:

4.0000 Each(s)



D37637



Tube

08.12.0

3.0



Comment: Qty.:

1.0000 Each(s)/Unit



Tube

4.0000 Each(s)



4.0



Comment: LARGE FABRICATION RESOURCE 1

1-make a 0.063" chamfer on D3763-1 fitting before ass'y

2-assemble and tack weld as per dwg D3763 using locating pin DT9039 ***remove pin before welding****

3-weld as per dwg D3763, QSI004 Alum. rod Batch: M

SP 08.12.04



D a. 1710.	оорио						
W/O:		WORK ORDER CHANGI	WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	-					:	
	i		ļ				
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _	

Disposition: _____ QA: N/C Closed: ____ Date: ____

NCR: WORK ORDER NON-CONFORMANC				WORK ORDER NON-CONFORMANCE (NCR)				
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector
				·				
-	<u>`</u>							
] 		
							1	
		-						

NOTE: Date & initial all entries

Resolution:

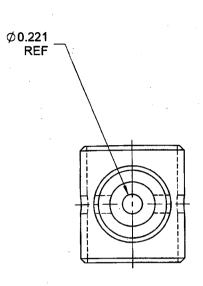
Friday, 17/10/2008 12:44:00 PM Date: User: Julie Dawson **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: END FITTING ASS'Y Job Number: 42724 Part Number: D3763045 Job Number: Seq. #: Machine Or Operation: Description: 5.0 QC9 VISUAL WELDING INSPECTION Comment: VISUAL 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify with Dart part # using a fine point permanent marker and Stock Location:-10.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

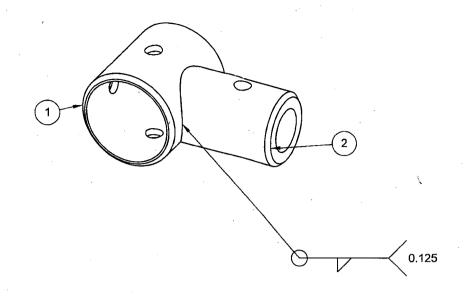
Dart Aerospace Ltd

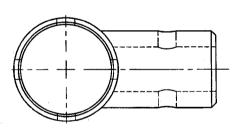
Duit Ac	ospace i	-14							
W/O:			WC	RK ORDER CHANG	ES				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						.,			
Part No		PAR #:	Fault Cated	gory:	NCR: Yes	No DQ	A :	_ Date: _	 ,
Resolution:		solution:	Disposition:		_ QA: N/C Closed:			Date:	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
		Description of NC	Corrective Action S		on B	Verific	cation	Approval Chief Eng	Approval
DATE	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	Section C	QC Inspector		
	,						-		·
		•							

NOTE: Date & initial all entries

Ø0.201 REF







ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3763-3	TUBE	1
2	D3763-1	FITTING	1

D3763-041 END FITTING ASSY

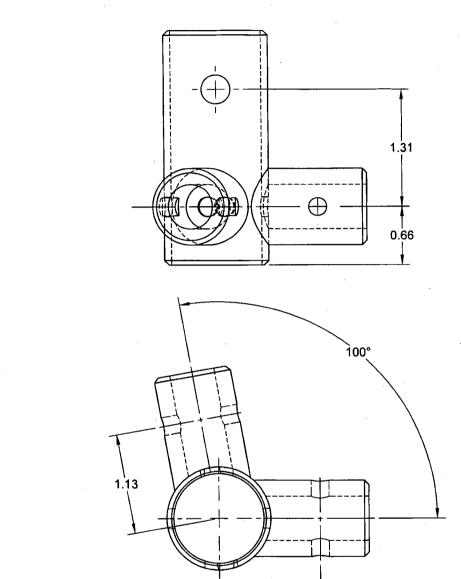
SHOF COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 100

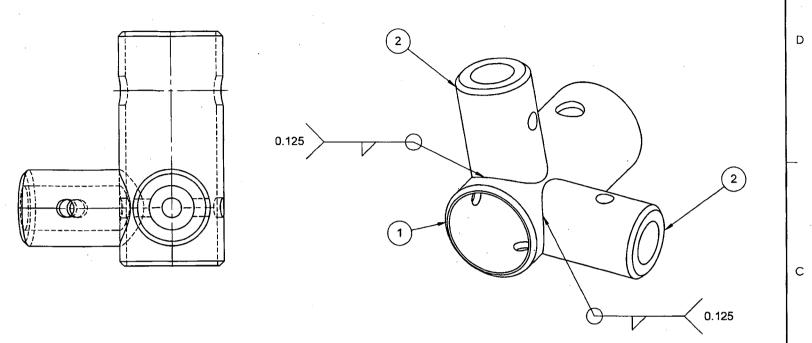
NIC	OTES:	* -			٠.
-					
	MATERIAL: N/A				
2)	FINISH: CHEMICAL CONVERSION COA	AT ASSEMBL'	Y PER	DART QSI	005 4.1
3)	TOLERANCES: PER DART QSI 018 UNI	LESS OTHER	WISE	NOTED	
4)	UNITS: INCHES UNLESS OTHERWISE	NOTED			
5)	BREAK SHARP EDGES: 0.005 TO 0.010) MAX			
-:	IDENTIFICATION AND ALLE				

6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs
8) WELD: PER DART QSI 004

С

В	CHANG	E HOLES SIZE,	ADD -7 PART AND -045 ASSY	HS	08.06,23
Α	NEW IS	SUE		HS	08.06.04
REV.			DESCRIPTION	BY	DATE
DESIG	N HS		DART AEROSE	ACE L	TD
DRAW	V	HS	HAWKESBURY, ONTA		
CHECK	ED	RH	DRAWING NO.		REV. B
MFG. A	PPR.		D3763		SHEET 1 OF 9
APPRO	VED	JM	TITLE	-	SCALE
DE AP	PR.	-#-	END FITTING		NTS
DATE	08.0	6.23	COPYRIGHT © 2008 BY DAR THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPI NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMI WRITTEN PERMISSION FROM DAR	PLIED ON THE EXPRES	S CONDITION THAT IT IS





ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-5	TUBE	1
2	D3763-1	FITTING	2

SHOP COPY RETURNTO

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK OF DER
NO. 47224

D3763-043 END FITTING ASSY, LH

С

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.05 lbs
8) WELD: PER DART QSI 004

DESIGN	HS	DART AEROSPA	ACE LTD
DRAWN	HS	HAWKESBURY, ONTARI	= ,
CHECKED	RU	DRAWING NO.	REV. B
MFG. APPR.		D3763	SHEET 2 OF 9
APPROVED	NA.	TITLE	SCALE
DE APPR.	M	END FITTING	NTS
DATE 08.0	06.23	COPYRIGHT © 2008 BY DART A THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNIC	ON THE EXPRESS CONDITION THAT IT IS

8 D 1.31 0.66 DESCRIPTION QTY. (-044) ITEM NO. PART NUMBER TUBE D3763-6 1 1.13 FITTING 2 D3763-1 2 SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT

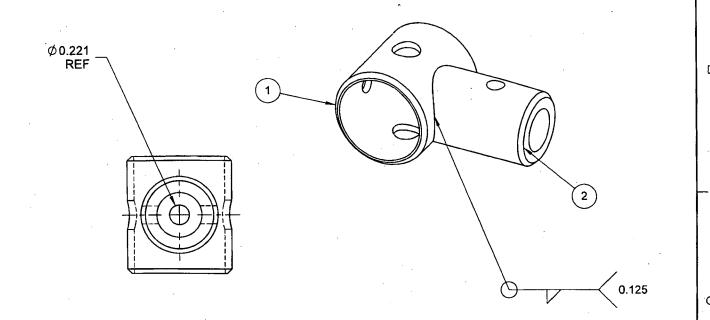
D3763-044 END FITTING ASSY, RH

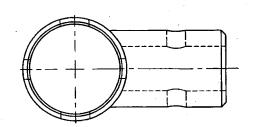
WITHOUT NOTICE

DESIGN	HS	DART AEROSP	ACE LTD
DRAWN	HS	HAWKESBURY, ONTAI	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	11/2	D3763	SHEET 3 OF 9
APPROVED	TAN	TITLE	SCALE
DE APPR.		END FITTING	NTS
DATE 08.0	06.23	COPYRIGHT © 2008 BY DART THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLINGT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATION.	LIED ON THE EXPRESS CONDITION THAT IT IS

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.05 lbs
8) WELD: PER DART QSI 004

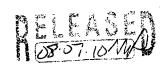
Ø0.323 REF — 1.13 **—**





ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)	
1	D3763-7	TUBE	1	
2	D3763-1	FITTING	1	

D3763-045 END FITTING ASSY



SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER
NO. 42

DESIGN	HS	DART
DRAWN	HS	HAWKES
CHECKED	PSI	DRAWING NO.
MFG. APPR.	M	D3763
APPROVED	M	TITLE
DE APPR.	111	END FITTING

AEROSPACE LTD SBURY, ONTARIO, CANADA REV. B SHEET 4 OF 9 SCALE NTS

COPYRIGHT © 2008 BY DART AEROSPACE LTD
THE DOCUMENT IS PRANTE AND COMPIDENTIAL AND IS SUPPLIED OUT THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WAITTEN PRANSISION FROM DART AEROSPACE LTD.

D

В

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs
8) WELD: PER DART QSI 004

8

08.06.23

Ø 0.50 THRU R0.580 ∠0.06 x 45° CHAMFER ALL AROUND ϕ 0.860 $^{+0.000}_{-0.010}$ **— 1.090 —** Ø0.201 🕦 THRU -0.05 X 45° CHAMFER - 0.545 -

D3763-1 FITTING

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COP SUBJECT TO AMENDMENT

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA HS HS DRAWING NO. REV. B D3763 SHEET 5 OF 9 TITLE SCALE **END FITTING** NTS

DRAWN CHECKED MFG. APPR. APPROVED DE APPR. COPYRIGHT @ 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITI
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON. DATE 08.06.23

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

 ϕ 1.010 $^{+0.010}_{-0.000}$ Ø0.221 B 0.66 Ø1.16 B B 0.66 -0.05 X 45° CHAMFER 2 PL Ø0.201 THRU B SHOP COPY RITURN TO ENGINEERING **D3763-3 TUBE** UNCONTROLLED COPY SUBJECT TO AMENDMENT DESIGN HS DART AEROSPACE LTD NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R) DRAWN HS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B (OR AMS 4117/4128/4115/4116) OR PER AWIS-QQ-7
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs MFG. APPR. SHEET 6 OF 9 APPROVED TITLE

DE APPR.

08.06.23

DATE

2

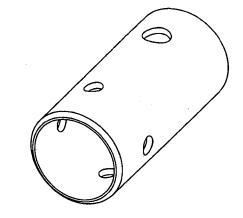
END FITTING

COPYRIGHT © 2008 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONTROLITEL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS

NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT

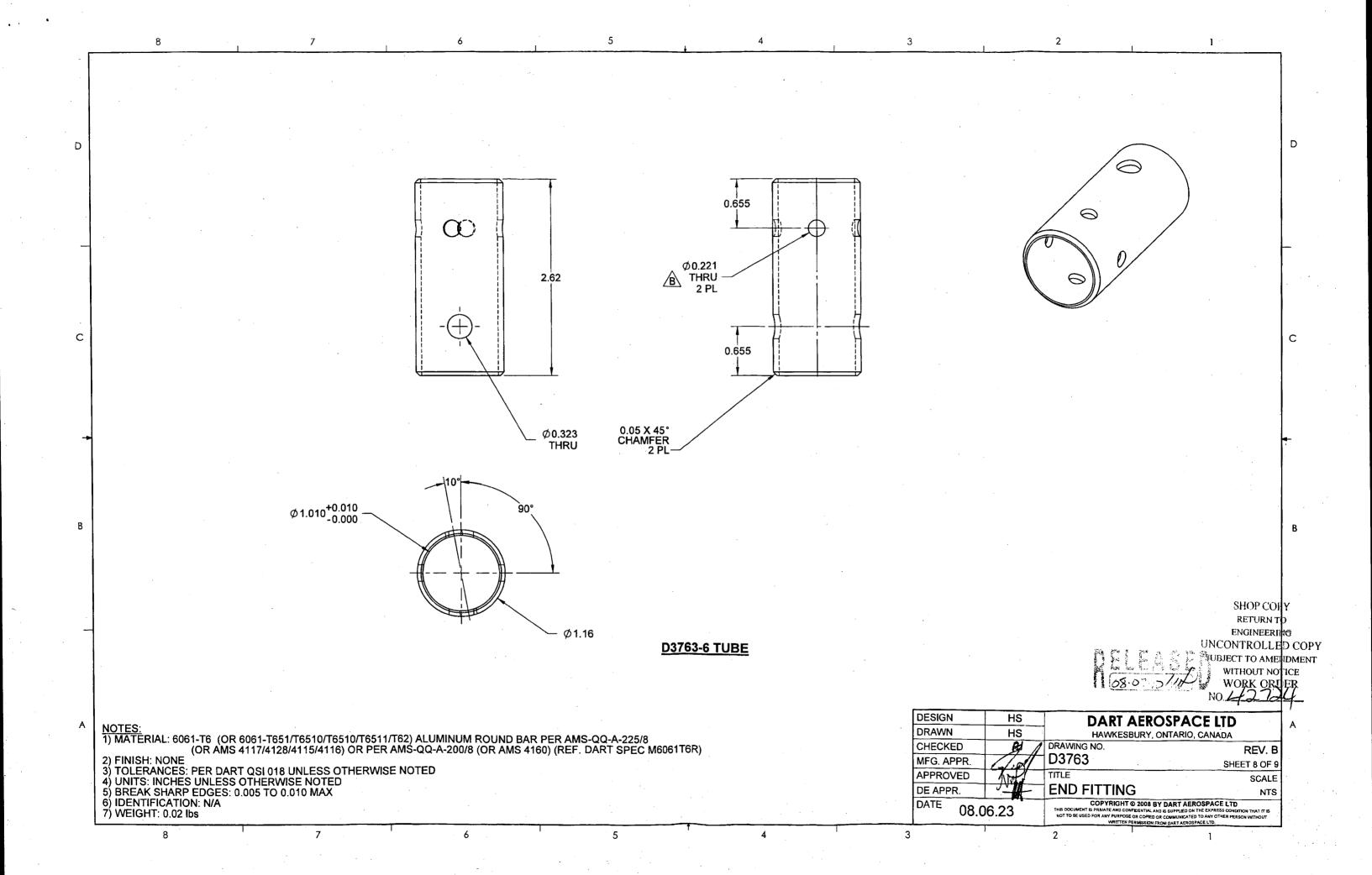
0.655 Ø0.323 THRU-2.62 ∞ С Ø0.221 THRU B 2 PL 0.655 0.05 X 45° CHAMFER-2 PL Ø1.010^{+0.010} **D3763-5 TUBE** Ø1.16 NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R) (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs



RETURN TO ENGINEERING COPY

SHOP COP

DESIGN HS DART AEROSPACE LTD DRAWN HS HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3763 CHECKED REV. B MFG. APPR. SHEET 7 OF 9 APPROVED TITLE SCALE **END FITTING** DE APPR. COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT DATE 08.06.23



Ø1.010^{+0.010} Ø0.221 THRU 0.66 Ø1.16 - 1.31 — -0.05 X 45° CHAMFER 2 PL 0.66 ϕ 0.323 THRU **D3763-7 TUBE**

SHOP COPY RETURNTO ENGINE PING UNCONTROLLED COP

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)

(OR AMS 4117/4128/4115) OR PER AMS-QQ-A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

8

HS	DART AEROSPACE LTD	
HS	HAWKESBURY, ONTARIO, CANADA	
AN /	DRAWING NO.	REV. B
CIA	D3763	SHEET 9 OF 9
1	TITLE	SCALE
V 24	END FITTING	NTS
06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTTO. WRITTEN PERMISSION FROM DART AEROSPACE LTO.	
	 	HS HAWKESBURY, ONTAR DRAWING NO. D3763 TITLE END FITTING COPYRIGHT © 2008 BY DART / THIS DOCUMENTS FRANTE AND CONFIDENTIAL AND IS SUPPLIE NOT TO BE USED FOR ANY PHYROSE OR COMPANY